

**Work Order ID 69328**

Monday, May 09, 2011 9:28:48 AM



Page 1

Item ID: D3021-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube Assembly

Start Date: 5/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*MF*

Date: 11-05-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3021

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tube as per Dwg D3021

2-Drill tube as per Dwg D3021 using D8622

3-Deburr

4-Weld as per Dwg D3021 QSI004

A/R 4130 Rod Batch: *mu 114509**EL 11-5-17 (A1)*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*1 0 BE 11/05/12*

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Page 2

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Start Date: 5/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

8465117



QC

Memo

0.00

Quality Control



130

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M115128

Memo

0.00

Powder Coating

START TIME: 1:30

OVEN TEMPERATURE: 320°

FINISH TIME: 2:00

1 BR 11-5-17

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 of 94 4/05/17

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Page 3

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Item Name: Tube Assembly

Start Date: 5/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

*w/p 69118*

0.00

Packaging

*EP 5/10/18*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/5/18**11-05-18*

# Picklist Print

Monday, May 09, 2011 9:28:45 AM

Page 1

Work Order ID: 69328

Parent Item: D3021-041

Parent Item Name: Tube Assembly

Start Date: 5/9/2011


Required Date: 5/16/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP 01.10.23 New Issue SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3017-11		Manufactured	No			100	Each	36.0000	2	2			
													
cap													

Location	Loc Qty	Loc Code
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WA	34	
69074	34	
WA019	2	
52583	2	

M4130NT0.750W.049		Purchased	No			100	f	33.4900	2.0833	2.192947			
													
4130 RD Tube .750 x.049W													

Location	Loc Qty	Loc Code
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MAT033	33.49	
110740	33.49	

M 117691 X 2.19

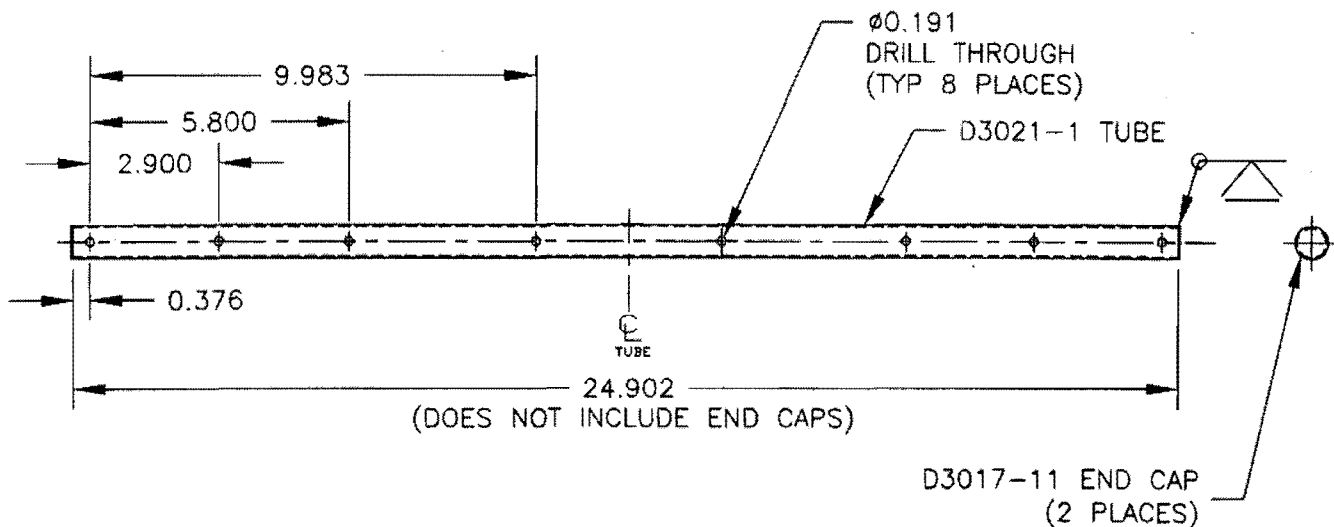
EL 11-5-17

EL 11-5-17



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	

*69328*



D3021-041 TUBE ASSEMBLY  
(D3021-1 TUBE)

NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE.
- 2) MATERIAL: AISI 4130 TUBE,  $\phi 0.75$  DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

**RELEASED**  
01.05.308

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